

Technical Data Sheet

Accuguard ABS860V0UVL

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics

General			
Features	• Flame Retardant		
UL File Number	• E51193		
Forms	• Pellets		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 Kg)	5.0 g/10 min	5.0 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	247000 psi	1700 MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	5950 psi	41.0 MPa	
Break	3920 psi	27.0 MPa	
Tensile Elongation			ASTM D638
Yield	4.0 %	4.0 %	
Break	25 %	25 %	
Flexural Modulus	348000 psi	2400 MPa	ASTM D790
Flexural Strength	8270 psi	57.0 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	6.7 ft·lb/in	360 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-scale)	92	92	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	171 °F	77.0 °C	
264 Psi (1.8 Mpa), Unannealed	151 °F	66.0 °C	
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating			UL 94
0.06 In (1.6 Mm)	V-0	V-0	
0.10 In (2.5 Mm)	5VA	5VA	

Technical Data Sheet

Accuguard ABS860V0UVL

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature - Desiccant Dryer	180 °F	82 °C
Drying Time - Desiccant Dryer	4.0 hr	4.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	380 to 440 °F	193 to 227 °C
Middle Temperature	380 to 440 °F	193 to 227 °C
Front Temperature	380 to 440 °F	193 to 227 °C
Processing (Melt) Temp	390 to 440 °F	199 to 227 °C
Mold Temperature	105 to 176 °F	41 to 80 °C
Injection Rate	Moderate	Moderate
Back Pressure ¹	70.0 to 200 psi	0.483 to 1.38 MPa
Screw Speed	50 to 150 rpm	50 to 150 rpm
Cushion	0.250 to 0.500 in	6.35 to 12.7 mm

Injection Notes

*8 Be sure to Purge Clear any FR Material from Barrel and Hot Runner system at extended downtimes or at Shutdown.

Notes

¹ Medium

Notes

These are typical property values not to be construed as specification limits.